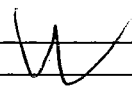
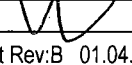


Date: Friday, 04/01/2008 9:23:05 AM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	OH-58 STEP ASSY LH *UNDER REVIEW**
<b>Job Number</b> :	36562	<b>Part Number</b> :	D058677011
<b>Estimate Number</b> :	12438	<b>Drawing Number</b> :	D2943 UNDER REVIEW
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	04/01/2008	<b>Drawing Revision</b> :	UNDER R
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	04/01/2008	<b>Due Date</b> :	11/01/2008
<b>Previous Run</b> :	31293	<b>Qty:</b>	4 Um: Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:B 01.04.11 Combined with D2943-041 EC		

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** Photocopy bluefile & type labels per PPPD058-677-011 CHG 001



2.0	D2622120C	Extrusion
-----	-----------	-----------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Extrusion D2622-120C  
Batch: B35618

SAD 08/01/10 (4)

3.0	D2734	206 Step Endplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
D2734 206 Step Endplate  
Batch: B 34485

08.01.10

4.0	D2725	206 Step Lug
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
D2725 206 Step Lug  
Batch: B36274

08.01.10

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

SAD 08/01/10 (4)

2-Deburr and bevel ends for welding

SAD 08/01/10 (4)

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 04/01/2008 9:23:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 36562

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: M105844

4-Grind end cap welds flush as per dwg D2943

*JE 08-01-15 4*

*SAD 08-01-15 (4)*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-01-15 (4)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JE 08/01/15 (4)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 08/01/17 (4)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BK 08-01-17 (4)*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: M105058

*JE 08-01-17 4*

2-Grind end cap welds flush as per dwg D2943

*SAD 08-01-18 4*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-01-22 (4)*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JE 08-01-22 (4)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 04/01/2008 9:23:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 36562

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Pressure wash as per QSI 005

2-Touch up Chemical Conversion Coat as per QSI 005 4.1

→ BR 08-01-23

(4)

14.0

POWDER COATING

POWDER COATING



M 106379



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-1 08/01/24

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: m 106332

FL 08/01/24

(4)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/25

(4011)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/25

(4011)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

Batch: 139112

SLP

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Lug

133995 (7X) 8/1/24 50

(4011)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 04/01/2008 9:23:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 36562

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: 122591

SP

22.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: 134125

SP

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: 1104214

SP

24.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

1105143

SP

25.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Washer

Batch: 1106297

SP

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

Batch: 1101938

8/1/24

SP

(4X)

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2004/25

(4X)

(4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 04/01/2008 9:23:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 36562

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev:

B

8/1/25 SD (4x)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.25 A

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.01.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

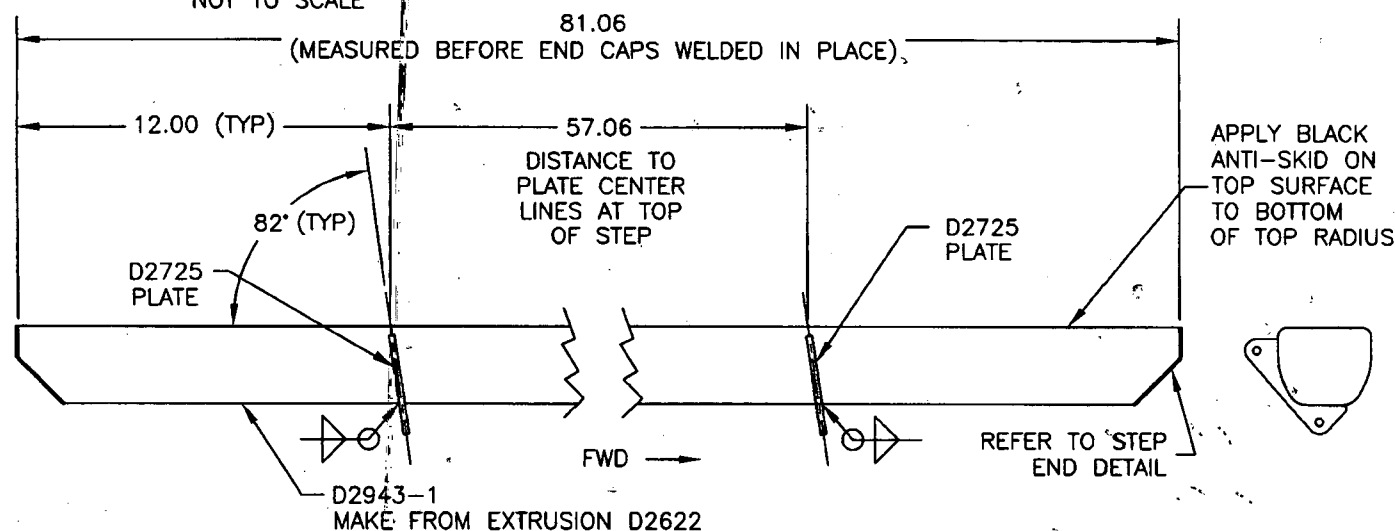
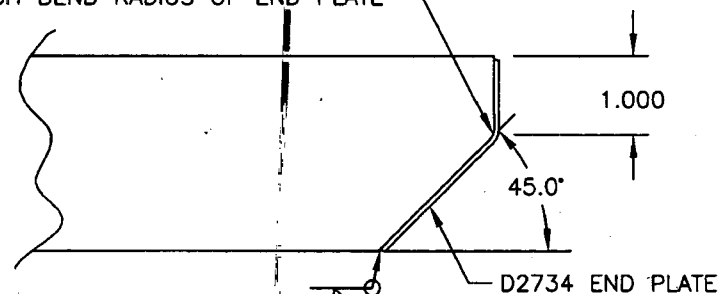
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



D2943-041 LH STEP ASSEMBLY (SHOWN)  
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

**D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

\*out per drawing

**D2943-041/-042 OH-58 STEP ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	RF	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED		APPROVED	PORT HADLOCK, WA
DATE	05.11.14	TITLE	OH-58 STEP ASSEMBLY
A	99.11.19	NEW ISSUE	REV. B
B	05.11.14	UPDATE FINISHING NOTE	SHEET 1 OF 1
			SCALE
			NTS

**UNDER REVIEW**

06.03.29 B#

RE-DESIGN  
COMPARING TO DRAW-628

**RELEASED**  
05.11.28

*Handwritten signature/initials*